

Date: Monday, 2/27/2006 4:17:53 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STRUT
Job Number	: 25969		
Estimate Number	: 10272		
P.O. Number	: N/A	Part Number	: D2562001
This Issue	: 2/27/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2562 REV D
First Issue	: N/A	Project Number	: N/A
Previous Run	: 24272	Drawing Revision	: D
		Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 3/20/2006
Checked & Approved By	: <u>06.02.28</u>	Qty:	10 Um: Each
Comment	: Est F 02.04.15 Added dwg Rev.B1 NG		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0500W035	304 RD Tube .500 x .035W
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Comment: Qty.: 1.7920 f(s)/Unit Total: 17.9204 f(s)  
 304/316/318-2B Seamless Tubing, 1/2" O.D. x 0.035" wall  
 Batch H 19480

FF 06.04.12 10

2.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE  
 Punch to length as per Dwg D2562

FF 06.04.12 10

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL/MED FAB RESOURCE  
 1- Bend end as per Dwg D2562 Angle "D"  
 2-Deburr

FF 06.04.21 10

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

06.04.23 10

5.0	POWDER COATING	POWDER COATING
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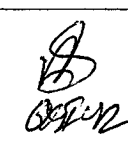
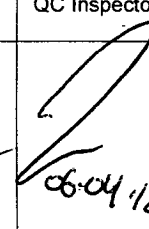
Comment: POWDER COATING  
 Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

DL 06/04/24 10

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06.04.12	2	<del>10 struts one end damaged (good for shorter struts)</del>	FP	06.04.12	10		

Part No: D2562-001 PAR #: N/A Fault Category: Prod / FAB. ASS <sup>needed serial</sup> NCR: Yes No DQA: FP Date: 06/04/2012  
 QA: N/C Closed: FP Date: 06.04.26

NCR: <u>25969</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06.04.12	2	Piece of Mat'l in strut punch left marks on the struts. Qty of 10 struts. Also dents.		Use the damaged struts for shorter struts. And replace the Qty of 10. Ensure punch is free of debris when using.	FP 06.04.12	 06.04.12		 06.04.12

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 25969

Part Number: D2562001

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



U 06.04.26

06/04/25 (10)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

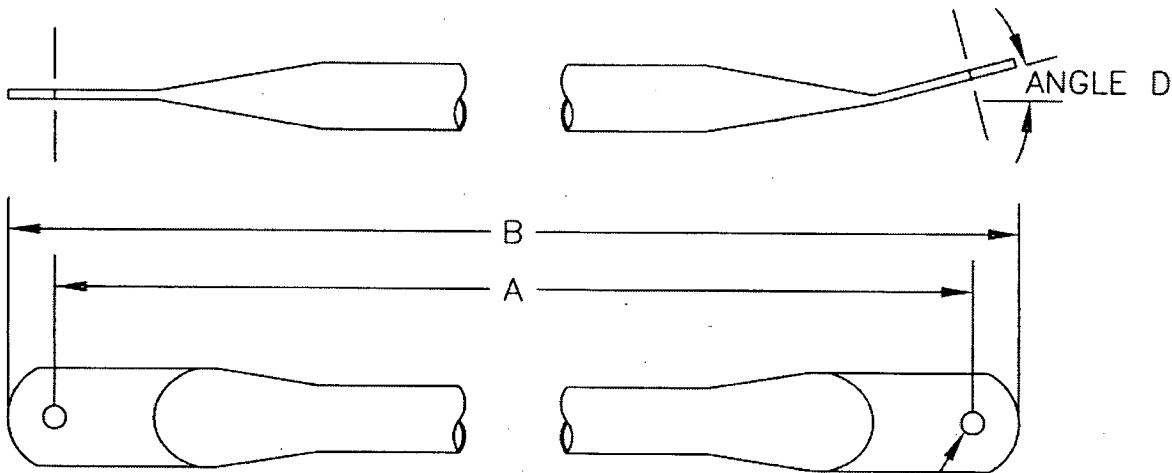
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN	CP	DRAWN BY	RF	DART AEROSPACE LTD
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	05.05.18	DRAWING NO.	D2562	REV. D
		TITLE	STRUT	SHEET 1 OF 1
		SCALE	1:2	
A	96.05.01	NEW ISSUE		
B	98.10.15	UPDATED MATERIAL NOTE (TSR A603)		
C	02.06.05	ADD -005; ADD FINISH		
D	05.05.18	ADD -007/-011/-013; UPDATE -005		



PUNCH ENDS PER SPEC CONTROL DRAWING D2727

PART #	DIM A	DIM B	DIA C	ANG D
✓ D2562-001	19.68	20.48	-	10
D2562-003	20.37	21.17	-	18
D2562-005	29.00	29.80	-	30
D2562-007	19.22	20.02	-	0
D2562-011	25.79	26.59	-	16
D2562-013	26.63	27.43	-	24

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 25969

#### GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.500 OD X 0.035 WALL (REF DART SPEC. M304TR0.500W.035) ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED

05.05.27

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